Ship Bepton

	r ID 107112 er 20, 2013 2:24:22 PM		*107	7112*						Page 1	
Revision ID:	D2170-1 Bracket		Accept	*N900	<b>040</b>	100	<b>)*</b> s	etup Start Stop	1 71	S1* S2*	<del></del> -
Start Date: 9 Required Date: 9 Reference:	9/20/2013 Start Qty: 9/27/2013 Req'd Qty:		* * 4 4 *	Cust Item I Customer:	D:						
Approvals:	Process Plan:	Date: 13-C	1-JO Tooling:	D:	ate:		R	un Start	*N	R1*	
	QC:	Date:			ate:			Stop	*N	R2*	
Sequence ID/ Work Center ID	Operation Description	- · · · · · · · · · · · · · · · · · · ·	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp	
Draw Nbr	Revision Nbr										
D2170	N/A										
*100 *100* Waterjet FLOW CNC Waterjet	1-C D	R JET  emo  Cut as per Dwg  wg Rev:	0.00				42	o		Au 13.59	· 23
		Deburr as required									
1110 *11 <b>0*</b> QC		arts off machine FAI/FAIB	0.00			. (	do			<i>J</i> e	<b>a</b> • •
Quality Control	Me	emo	0.00							13,00	1.23

DQA:		Dat	e:		WORK ORDER NON-CONFORMANCE / UPDATE							
QA Closed:		Dat	۰.		WORK ORDER NON-	-CC	ONFO	RMANCE / UPDATE	· \// o	ork Order up	ndate only - F	AEROSPACE
Q. Closed.					DISPOSITION.					·		
Work Orde	er:	_			DISPOSITION			AGAINST	DEF	PARTMENT	/PROCESS	
					Rework			Skid-tube Crosstube			Water Jet	Engineering
Part N	No				Scrap			Machining Small Fab	Ò	Pro	d. Eng. Coor.	Quality
					Use-as-is		Therr	moforming Finishing	-	Rec/Sto	re/Packaging	Other
NCR I	No			<del></del>	Suspected Unapproved			Large Fab Composite	: 		Supplier	
Root				Desc	ription of work order update		I Initial	Action		Sign &		· ·
Cause	Da	ite Ste	p Qty		or non-conformance	Ch	nief Eng	Description		Date	Verification	QC Inspector
Design												
Doc/Data												
Equip/Tooling					* Qu							
Handling/Pre									Ì			
Material					* *							
Operator												•
Offset/Setup		]								a V	·	,
Process												
Supplier			' '	,								
Training												
Transport												
Unapproved				<u> </u>							<u> </u>	
						FAl	ULT CA	TEGORY				
Landii	ng Gear			_	General		1 .				<u></u>	_
	Benc	•		_	Bend	Ш	1	Program	$\vdash$	Outside Dim	<u> </u>	Pressure/Forced
	_	re Not Cond	centric	_	BOM/Route		Grain		-	Over/Under	_	Set-up
	Cracl				Broken/Damage/Defect	Ш	Hardwa		$\vdash$	Part Incorred	<b> </b>	Temperature/Cure
	_	p/Kink/Ripp	ole/Wave		Burrs		į.	ion Incomplete/Unqualified	_	Part Lost/Mi	ssing	Weld
ļ	Cuffs				Contamination		1	tions Incomplete/Unclear	-	Part Moved		Wrong Stock Pulled
	Crusi	_			Countersink	$\vdash$	•	gned/off center	$\vdash$	Positioned V		_
		Treat		<u> </u>	Cut Too Short	$\vdash$	Mislabe			Power Loss/	Surge	Other
ļ		ection Strip	ın Tube	-	Drawing	$\vdash$	Misread		-		· · · · · · · · · · · · · · · · · · ·	
		cs/Chatter			Drill Holes		Off-set		_			
	Turning Sequence			_	Finish		i	Calibration	-			
• •	Wave/Twist in Tube				Fit/Function		Out of S	Sequence				

Work Orde Friday, Septemb				*107	7112*						Page 2	
Item ID: Revision ID: Item Name:	D2170-1 Bracket			Accept	*N900	<b>040</b>	100	<b>)*</b> - s	etup` Sta	1 7	S1* S2*	
Start Date: Required Date: Reference:	9/20/2013 9/27/2013	Start Qty: 2.00 Req'd Qty: 2.00		2* 2*	Cust Item II Customer:	D:						
Approvals:	QC:		Date:	Tooling:	Da	te:	_	R	Run Sta	1/1	R1*	
			Date:	SPC (Y/N):	Da			Sto	*N	R2*		
Sequence ID/ Work Center ID			,	Set Up/ Run Hours	Tool ID	Tool #	# Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp	
*120 *120*		QC8- Inspect parts - seco	ond check	0.00	•			PE				
QC Quality Control		Memo		0.00 13 9.	33				·			
130		Bend as per dwg		0.00							P	
*130* Brake NC		Memo		0.00				<u>v</u>			Sp (	

140

\*14**0**\*

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

DQA: QA Closed:	AN ON	7	Date:	13/10/	4	WORK ORDER NOI	N-C	ONFOI	RMANCE / UPDATE	Vork Order u	odate only	DART
Work Orde Part N NCR N		D ê	7 (18 3 (70 309)	2 ~	 	DISPOSITION  Rework  Scrap  Use-as-is  Suspected Unapproved			Skid-tube Crosstube Small Fab Finishing Composite	<del></del>	/PROCESS  Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root Cause	Da	te	Step	Qty	Desci	ription of work order update or non-conformance		Initial nief <sub>,</sub> Eng	Action Description	Sign & Date	Verification	QC Inspector
Design Doc/Data Equip/Tooling Handling/Pre Material Operator Offset/Setup Process Supplier Training Transport Unapproved		124	(30	2	_	for fast bend Up Parts + Day. CLEAR. / PROCESS.	13	DAS 16 9-89 >70-12 110/02	Surp duty	96 13/09/14	139 DY	0070112 13/10/17
Landi	ng Gear					General		OLI CAI	LOOKI			
	Bend Cent Cracl Crim Cuffs Crusl Heat Inspe	re Not cs p/Kink ning Treat ection s cs/Chai	Strip in	/Wave Tube		Bend BOM/Route Broken/Damage/Defect Burrs Contamination Countersink Cut Too Short Drawing Drill Holes Finish Fit/Function		Instruct Misalig Mislabe Misread Off-set Out of O	re on Incomplete/Unqualified ions Incomplete/Unclear ned/off center	Outside Dim Over/Under Part Incorred Part Lost/Mi Part Moved Positioned V Power Loss/	tolerance ct ssing	Pressure/Forced Set-up Temperature/Cure Weld Wrong Stock Pulled Other

Work Ord Friday, Septen				*107	7112*	,					Pag	
Item ID: Revision ID: Item Name:	D2170-1 Bracket			Accept	*N900	<u>040</u>	100	<b>)</b> *	Setup Sta	ΙVI	S1*	
Start Date: Required Date Reference:	9/20/2013 Start Qty: 2.00 Req'd Qty: 2.00		*2* *2*		Cust Item 1 Customer:							
Approvals:	Process Pl	an:	Date:	Tooling:	D	ate:	_	1	Run Sta	"   1/1	R1*	
	QC:		Date:	SPC (Y/N);	D	ate:			Sto	*N	*NR2*	
Sequence ID/ Work Center	ID	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp	
150		Chemical Conversion Co	oat per QSI005 4.1	0.00							_	
*150* 'HandFinish Hand Finishing		Memo		0.00				2	NG	1396	25	
160		QC7-Inspect Chemical C	Conversion Coat	0.00					•			
*160*		Memo		0.00				2x	·		GA	

170

Identify as per dwg & Stock Location: 6

0.00

\*170\* Packaging

Packaging

Quality Control

Memo

0.00

Memo

Page 3

DQA:		_ Date:			WORK ORDER NON-CONFORMANCE / UPDATE							
		Date			WORK ORDER NON-	-CC	ONFO	RMANCE / UPDATE				AEROSPACE
QA Closed:		Date:					·		W	ork Order up	odate only	
Work Orde	r:				DISPOSITION			AGAINST	T DE	PARTMENT	/PROCESS	
				_	Rework			Skid-tube Crosstube	٦	]	Water Jet	Engineering
Part N	0.				Scrap			Machining Small Fat	-	Pro	d. Eng. Coor.	Quality
				_	Use-as-is		1	moforming Finishing			re/Packaging	Other
NCR N	o				Suspected Unapproved			Large Fab Composite	~	]	Supplier	
Root	<u> </u>	<u> </u>	T I	Desci	ription of work order update		Initial	Action		Sign &		
Cause	Date	Step	Qty	Desci	or non-conformance		nief Eng			Date	Verification	QC Inspector
Design	- Julie	эсер	(1,7)		or non-comormance	CII	nerieng	Description		Date	verincation	QC IIISPECTOI
Doc/Data	_											
Equip/Tooling	<b>⊣</b> .											
Handling/Pre		j	]									
Material												
Operator												
Offset/Setup		1										·
Process	-											
Supplier												
Training			1 1									
Transport			1 1									
Unapproved												
						FAL	ULT CAT	regory				· .
Landin	g Gear				General							
<u> </u>	Bending				Bend [		Folio/P	rogram		Outside Dim	ensions	Pressure/Forced
	Centre No	ot Concer	ntric		BOM/Route [		Grain			Over/Under	tolerance	Set-up
_	Cracks				Broken/Damage/Defect		Hardwa	re		Part Incorrec	ct	Temperature/Cure
_	Crimp/Kir	nk/Ripple	e/Wave		Burrs		Inspecti	ion Incomplete/Unqualified		Part Lost/Mi	ssing	Weld
_	Cuffs			Contamination		Instruct	ions Incomplete/Unclear		Part Moved		Wrong Stock Pulled	
	Crushing				Countersink		Misalig	ned/off center		Positioned W	/rong	
<u> </u> _	Heat Trea				Cut Too Short		Mislabe	eled		Power Loss/S	Surge	Other
	Inspection		Tube		Drawing		Misread					
L	Marks/Ch			<del></del>	Drill Holes	-	Off-set					
<u> </u>	Turning Sequence			$\vdash$	Finish	Out of Calibration						
^ , ·					Fit/Function		Out of S	Sequence				

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Work Ord Friday, Septem				Page 4					
Item ID: Revision ID: Item Name:	D2170-1 Bracket			Accept	*N900040	100	* Setu	p Start Stop	ולימו
Start Date: Required Date Reference:	9/20/2013 e: 9/27/2013	Start Qty: 2.00 Req'd Qty: 2.00	*2* *2*		Cust Item ID: Customer:				
Approvals:	Process Pl	an:	Date:	Tooling: SPC (Y/N):	Date:		Run	Start Stop	"INK1"
Sequence ID/ Work Center 180 *180* QC Quality Control	ID	Operation Description QC21- Final Inspection Memo	- Work Order Release	Set Up/ Run Hours 0.00	Tool ID Tool #	Plan Code	_	k Rm	Reject Insp. Number Stamp  13/09/26  MF 9.2=

DQA:		_ Date:										
					WORK ORDER NON-	-C(	ONFO	RMANCE / UPDATE			_	AEROSPACE
QA Closed:		Date:							Work	Order up	odate only	
Work Orde	er:				DISPOSITION			AGAINST	DEPA	RTMENT	/PROCESS	
4.				_	Rework			Skid-tube Crosstube	П		Water Jet	Engineering
Part N	١٥.				Scrap			Machining Small Fab	—	Pro	d. Eng. Coor.	Quality
					Use-as-is			moforming Finishing			re/Packaging	Other
NCR N	١٥.				Suspected Unapproved			Large Fab Composite	_	·	Supplier	
		-										
Root				Desci	ription of work order update	-	Initial	Action		Sign &		" "
Cause	Date	Step	Qty		or non-conformance	Ch	nief Eng	Description		Date	Verification	QC Inspector
Design												
Doc/Data							•					
Equip/Tooling												
Handling/Pre												
Material												
Operator												
Offset/Setup												
Process	_				·			·				
Supplier								,				
Training					• •							
Transport	_											,
Unapproved												
	<del></del> -				· · · · · · · · · · · · · · · · · · ·	FAI	ULT CA	TEGORY				
Landir	ng Gear				General		1 .			•	<b>-</b> -	
	Bending			_	Bend		1	Program	—	itside Dim	<b> -</b>	Pressure/Forced
		lot Conce	ntric		BOM/Route		Grain			er/Under	·	Set-up
		Cracks			Broken/Damage/Defect		Hardwa	·		rt Incorrec	_	Temperature/Cure
ŀ		ink/Ripple	e/Wave	-	Burrs		1	ion Incomplete/Unqualified	<del></del>	rt Lost/Mi	ssing	Weld
ŀ	Constitute		ļ	Contamination	-	4	tions Incomplete/Unclear	⊢	rt Moved	. L	Wrong Stock Pulled	
	Crushing				Countersink		1 .	gned/off center		sitioned W		<b>¬</b> .
	Heat Tre		<b>-</b> 1		Cut Too Short		Mislabe		∐_Ро	wer Loss/S	Surge	Other
	Inspection Strip in Tube			Drawing	Misread							
	Marks/Chatter				Drill Holes		Off-set					
e		Sequence			Finish	-	4 .	Calibration				
	Wave/Twist in Tube			l l	it/Function Out of Sequence							

Friday, September 20, 2013 2:24:22 PM

Work Order ID:

107112

Parent Item:

D2170-1

Parent Item Name:

Bracket

**Start Date:** 9/20/2013

Required Date: 9/27/2013

Start Qty: 2.00

Required Qty: 2.00

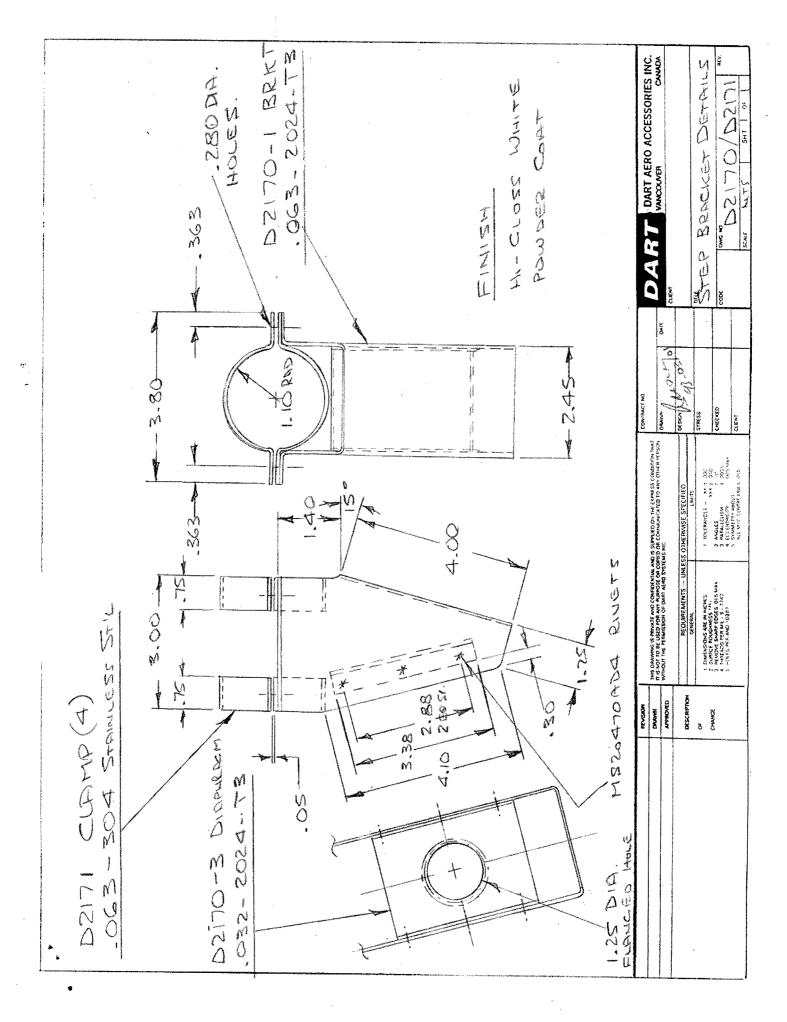
Comments:

IPP REV:A 13.09.18 NEW ISSUE DD VERE:JFS

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
<b>M2024T3S.063</b> 2024-T3 .063 sheet		Purchased	No	:			sf	396.1789		0.8105263		te_	3-09
				<b>Location</b>		Loc Qty	<u>Lo</u>	c Code					
			•	MAT022		396.1789							
				1199	916	0.2							
				1211	97	21.34							
				1230	96	11.4							
			•	1236	554	11.64							
				1237	01	31.7039			12	3701 .	$\longrightarrow$	-\$	H—
				1253		89.44							
				1256	36	230.455						1.6	<b>つ</b>

DQA:		Date:			WORK ORDER NON-CONFORMANCE / UPDATE							
QA Closed:		Date:			WORK ORDER NON	-C(	UNFO	RIVIANCE / UI		Vork Order u	pdate only	AEROSPACE
Work Orde	or.				DISPOSITION			-	AGAINST D	EPARTMENT	/PROCESS	-
WOIR OIG					Rework	1		Skid-tube	Crosstube	-	Water Jet	Engineering
Part N	No.				Scrap	1		Machining	Small Fab	Pro	d. Eng. Coor.	Quality
					Use-as-is	1		noforming	Finishing	<b>—</b>	re/Packaging	Other
NCR I	No				Suspected Unapproved	]		Large Fab	Composite		Supplier	
Root			T .	Desci	ription of work order update		Initial	Acti	ion	Sign &	·	1 .
Cause	Date	Step	Qty	0 000.	or non-conformance	1	nief Eng			Date	Verification	QC Inspector
Design			13.7			<u> </u>		2 0001	·peron	- Butte	Vermedien	Qe ilispector
Doc/Data												
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Handling/Pre												
Material												
Operator												
Offset/Setup												
Process												
Supplier										1.		
Training										,	,	• •
Transport												
Unapproved	,											
						FAI	ULT CAT	TEGORY				•
Landi	ng Gear				General							
	Bendin	g			Bend		Folio/F	Program		Outside Dim	ensions	Pressure/Forced
	Centre	Not Conce	ntric		BOM/Route		Grain			Over/Under	tolerance	Set-up
	Cracks				Broken/Damage/Defect		Hardwa	ire		Part Incorre	ct	Temperature/Cure
	Crimp/I	Kink/Ripple	e/Wave		Burrs		Inspect	ion Incomplete/Un	qualified	Part Lost/Mi	issing	Weld
	Cuffs				Contamination		Instruct	tions Incomplete/U	Inclear	Part Moved		Wrong Stock Pulled
	· Crushin	g			Countersink		Misalig	ned/off center		Positioned V	Vrong	<del></del>
-grit	Heat Tr	eat			Cut Too Short		Mislabe	eled		Power Loss/	Surge	Other
יייד	<b>—</b>	ion Strip in	Tube		Drawing		Misread	d				
	Marks/	Chatter			Drill Holes		Off-set					
	Turning Sequence			Finish		Out of (	Calibration					
•	Wave/Twist in Tube				Fit/Function		Out of	Sequence				

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DQA:		_ Date:			WORK ORDER NON-CONFORMANCE / UPDATE								
					WORK ORDER NON-	-CC	ONFO	RMANCE / UPDATE			_	AEROSPACE	
QA Closed:		Date:							W	ork Order up	odate only		
Work Orde	er:			:	DISPOSITION			AGA	INST DE	PARTMENT	/PROCESS		
					Rework			Skid-tube Cross	tube	7	Water Jet	Engineering	
Part N	lo				Scrap			Machining Small	Fab	Pro	d. Eng. Coor.	Quality	
*.					Use-as-is		Therr	·	hing	Rec/Sto	re/Packaging	Other	
NCR N	lo		··· -		Suspected Unapproved			Large Fab Compo	osite	_	Supplier		
Root				Desci	ription of work order update	Ī	nitial	Action		*Sign &			
Cause	Date	Step	Qty		or non-conformance	Ch	ief Eng	Description		Date	Verification	QC Inspector	
Design												,	
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Handling/Pre	_							;					
Material		]											
Operator Offset/Setup	-												
Process	_												
Supplier													
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Transport	7				•			•					
Unapproved													
						FAL	ULT CA	TEGORY		-t			
Landir	ng Gear		•		General								
	Bending				Bend		Folio/F	Program		Outside Dim	ensions	Pressure/Forced-	
.	Centre I	Not Conce	ntric	· ,	BOM/Route		Grain			Over/Under	tolerance	Set-up	
	Cracks				Broken/Damage/Defect		Hardwa	are		Part Incorred	it [	Temperature/Cure	
	Crimp/Kink/Ripple/Wave				Burrs		Inspect	ion Incomplete/Unqualified		Part Lost/Mi	ssing	Weld	
`	<del></del>				Contamination	-	1	tions Incomplete/Unclear		Part Moved		Wrong Stock Pulled	
	<del></del>			Countersink		1	gned/off center		Positioned W				
}					Cut Too Short	⊢—	Mislabe		L	Power Loss/S	Surge	Other	
}	·				Drawing		Misread						
}	Marks/Chatter					rill Holes C				· · · · · · · · · · · · · · · · · · ·			
					Finish	Out of Calibration							
		wist in Tul	oe Je	1_	Fit/Function	Out of Sequence							

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